

ASAP

Work Order ID 66640



Page 1

Wednesday, February 23, 2011 11:19 AM

**PRELIMINARY ISSUE**

Accept

Item ID: D4319-5

Revision ID: PRELIM

Item Name: GPS Bracket

Start Date: 2/23/2011 Start Qty: 2.00

Required Date: 2/23/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start   
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4319	<u>PA4</u> A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per Dwg D3199								
<u>66640 . 080</u>	Dwg Rev: <u>PA4</u>								
	Prog Rev: <u>PA4</u>								
	Deburr if required								

11-2-23

(3)






110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									



11-2-23




**Work Order ID 66640**

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Page 2

Item ID: D4319-5 Accept  Setup Start   
Revision ID: PRELIM Stop   
Item Name: GPS Bracket  
Start Date: 2/23/2011 Start Qty: 2.00  Cust Item ID:  
Required Date: 2/23/2011 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	- inspector to pay Dry only 8/10/23 (x4)						
130  Brake NC Brake NC	Bend as per dwg Small Fab  Memo	0.00 0.00	JB 11/02/23			3			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	- inspector to pay Dry only 8/10/23 (x3)						

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Wednesday, February 23, 2011 11:19:14 AM

Page 3

Item ID: D4319-5

Accept

Revision ID: PRELIM

Item Name: GPS Bracket

Start Date: 2/23/2011 Start Qty: 2.00

Required Date: 2/23/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

145

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

3 0 11-2-23

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115951

Memo

0.00

Powder Coating

START TIME: 8:20  
OVEN TEMPERATURE: 320°  
FINISH TIME: 8:50

3 0 11-2-24

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3 0 11-2-24

**Work Order ID 66640**

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Item ID: D4319-5

Accept

Revision ID: PRELIM

Item Name: GPS Bracket

Setup Start

Stop

Start Date: 2/23/2011 Start Qty: 2.00

Required Date: 2/23/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

11/3/11 1st (32)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C/O C only  
NON AIR WORK 11/03/03  
U 1103.01

POSITIVE RECALL

EFFECTIVE 11/02/03 AUTH U

RELEASED 11/03/03 DATE 11/03/03

# Picklist Print

Wednesday, February 23, 2011 11:19:11 AM

Page 1

Work Order ID: 66640



Parent Item: D4319-5



Parent Item Name: GPS Bracket



Start Date: 2/23/2011

Required Date: 2/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.02.23 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080  6061-T6 .080 Sheet		Purchased	No				sf	248.1000		0.113684			
												11-2-23	

Location

Loc Qty

Loc Code

MAT

248.1

116268

56.1

116700

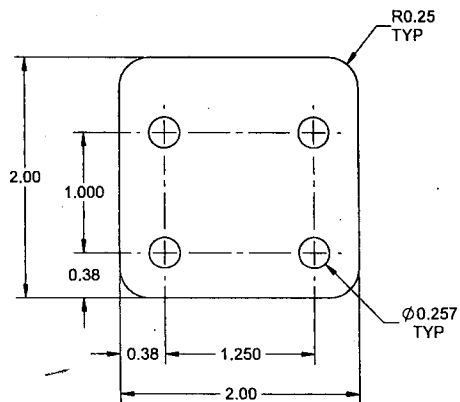
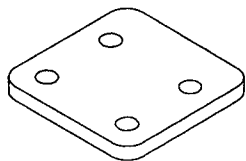
192

116268

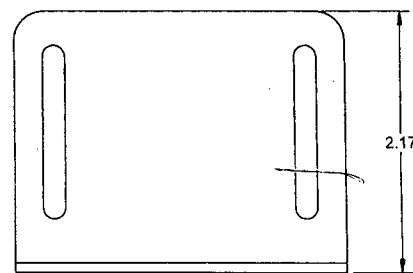
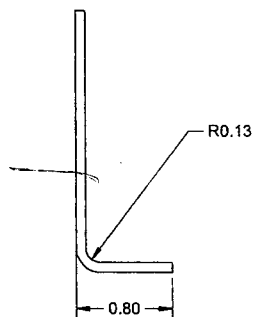
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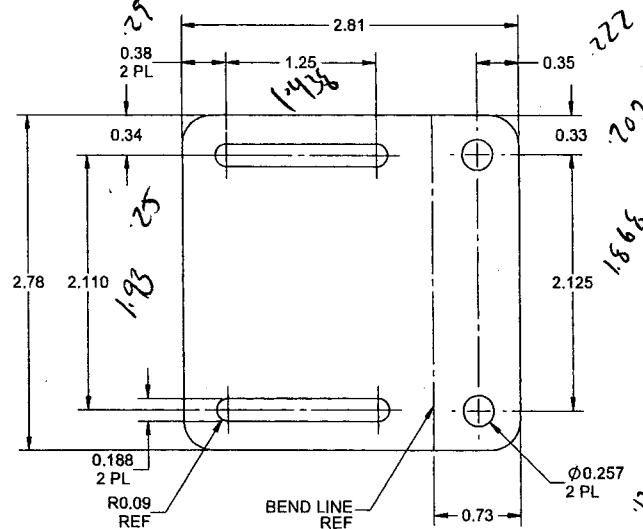
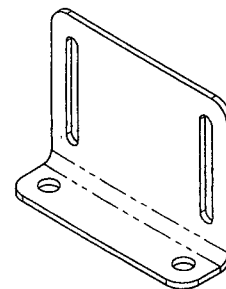




**D4319-3 SPACER**



**D4319-5 GPS BRACKET**



**D4319-5F FLAT PATTERN**

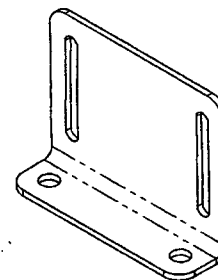
**NOTES:**

- 1) MATERIAL -3: 6061-T6/T62 ALUMINUM SHEET 0.188 THICK PER QQ-A-250/3 OR AMS QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188)
- 5: MAKE FROM -5F
- 5F: 6061-T6/T62 ALUMINUM SHEET 0.080 THICK PER QQ-A-250/3 OR AMS QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4319-X" AND B/N "BXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -3: 0.07 lbs  
-5: 0.02 lbs

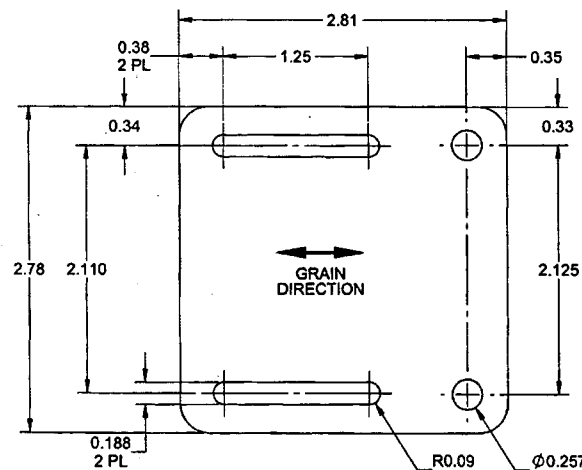
**PRELIMINARY A4**  
11.02.22 (AJS)

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		<b>D4319</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKETS</b>	NTS
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## **D4319-5 GPS BRACKET**



**D4319-5F FLAT PATTERN**

26640

RELEASE  
2011-03-02

**NOTES**

- 1) MATERIAL -3: 6061-T6/T62 ALUMINUM SHEET 0.188 THICK PER  
QQ-A-250/3 OR AMS QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188)  
-5: MAKE FROM -5F  
-5F: 6061-T6/T62 ALUMINUM SHEET 0.080 THICK PER  
QQ-A-250/3 OR AMS QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4319-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -3: 0.07 lbs  
-5: 0.02 lbs

DESIGN	MF	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4319</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BRACKETS</b>	NTS
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